

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002043**Date Inspected:** 02-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Li Wen Sheng
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Tower mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

77 meter Mock-Up, Z. P. M. C. Welder, Zhai Qingshan—058026, did not have a Caltrans Welder certification card. He left, went home, and returned with it. The Quality Assurance Inspector impressed upon Z. P. M. C. Quality Control (QC) personnel, the importance of welders having their welder certification card on their person. Weld number MUA-MA1-D/F-14A, grind welds, and place heaters. QA personnel were told by QC Inspector Shen that Magnetic Particle Testing would begin at approximately 16:10, this did not happen. Z. P. M. C. QC personnel started Magnetic Particle Testing (MT). The QA Inspector, did a quick preliminary Visual Inspection, noticed entrapped slag, notified QC—(no interpreter was present) was told that the Certified Welding Inspector (CWI) for Z. P. M. C. had stated that it was good. The fabricator stopped the MT and ground out the slag.

89-meter Mock-Up, Z. P. M. C. personnel are in the process of fitting up Skin D. At this moment the landing at Skin D to Skin E, is approximately 8mm below, the root bevel of Skin E. The root gap, at this location is 3.25mm to 9.25mm, however, fit-up is still in progress. 114 meter Mock-Up, weld number MUC-MA111, Skin C to Skin D, back gouge interior side of the joint. Weld numbers are not visible as required.

Summary of Conversations:

Without an interpreter present, the QA Inspector tried to communicate with Z. P. M. C. QC personnel, in regards to weld number placement and welders having their Welder Qualification card on their person.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
